

Date: Friday, 11/18/2005 5:53:18 PM
 User: Linda Lacelle

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	: LUG BRACKET
Job Number	: 24899		
Estimate Number	: 10009		
P.O. Number	: N/A	Part Number	: D27351
This Issue	: 11/18/2005 S.O. No. : N/A	Drawing Number	: D2735 REV C
Prsh Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: C
Previous Run	: N/A	Material	: N/A
Written By	: SEE COMMENT BELOW	Due Date	: 12/15/2005 Qty: 50 Um: Each
Checked & Approved By	: SPB COMMENT BELOW		
Comment	: Est Rev:C Removed from 9 Digit 05-10-25	JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
	Comment: PURCHASING Issue P/O: 146 E-mail or Ship DXF file to vendor Laser cut flat pattern as per Dwg D2735 Possible supplier: Ind. Laser Material realease note is required.	
2.0	D27351F	Lug Bracket
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s) Lug Bracket	
3.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage Ensure material certification is attached	
4.0	QC6	DIMENSIONAL CHECK
	Comment: DIMENSIONAL CHECK Inspect dimensions per templates D2735-1T1 & DWG D2735	
5.0	BRAKE NC	NC BRAKE
	Comment: NC BRAKE 1-Form D2735-1 as per Dwg D2735. Use CNC Brake Jig DT8204 2-Deburr if required.	

SP 06/01/26 49

W/O:		WORK ORDER CHANGES					Approval Chief Eng / Prod Mgr	Approval QC Inspector
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty		

Part No: D235 - 1

PAR #: N/A

Fault Category: Supplier -

NCR: Yes

No

DQA: X

Date: 06/01/27

INDUST. LASER

QA: N/C Closed: X

Date: 06/01/27

NCR: 29899		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-01-17	4	1 part scrap. holes are way off location on one end. holes done during laser cut.	BB 06/01/17	Scrap and destroy	J 06-01-17	J 06-01-17	BB 06/01/17	J 06-01-17

NOTE: Date & initial all entries

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Drawing Name: LUG BRACKET

Job Number: 24899

Part Number: D27351

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

AA 06/01/26

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

AA 06/01/26

8.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21 SUC 06/02/01

49

DP 06/01/27

Job Completion



W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

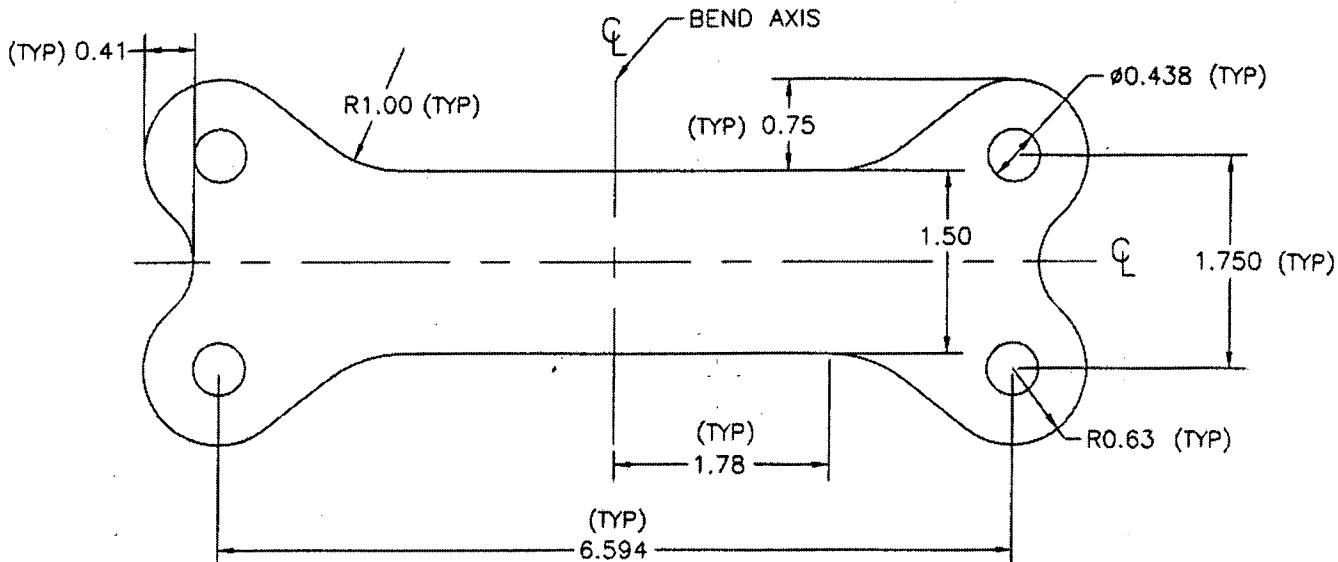
NOTE: Date & initial all entries

DART

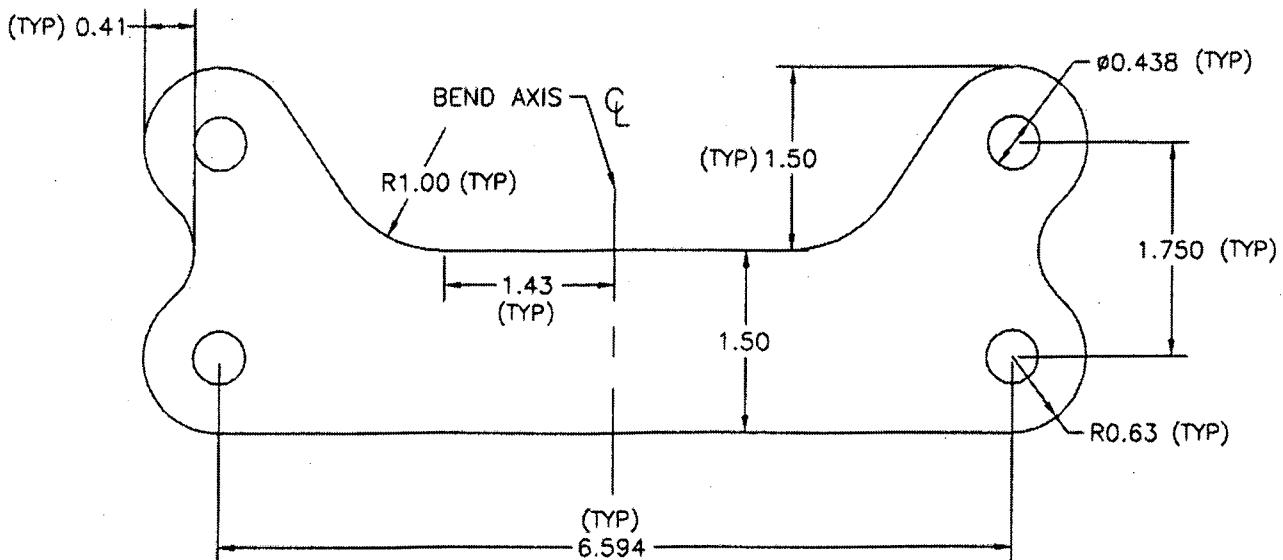
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. C
	CP	D2735	SHEET 1 OF 2
DATE		TITLE	SCALE
98.12.14		LUG BRACKET	2:3
A	97.12.14	NEW ISSUE	
B	98.10.23	UPDATE MATERIAL (TSR A1114)	
C	98.12.14	REMOVE TOOLING HOLES (TSR A1040)	

RELEASED

98.12.14 DS



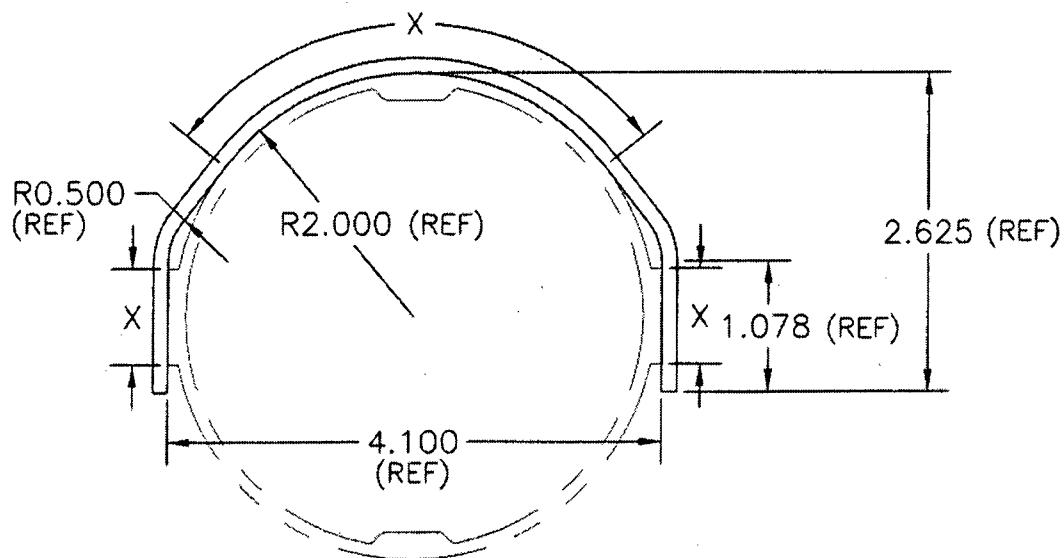
D2735-1 FLAT PATTERN
SYMMETRIC ABOUT BOTH CENTRE-LINES (C)



D2735-3 FLAT PATTERN
SYMMETRIC ABOUT CENTRE-LINE (C)

DART

DESIGN <i>PF</i>	DRAWN BY <i>PF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>KE</i>	DRAWING NO. D2735	REV. C SHEET 2 OF 2
DATE 98.12.14		TITLE LUG BRACKET	SCALE 2:3

RELEASED
18.12.14 DSD2735-1 AND D2735-3 BEND DETAIL

D2735-1 AND D2735-3 SHOULD BE BENT TO WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2500-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

GENERAL NOTES

MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL
0.125 THICK (11 GAUGE)
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi
MIN. YIELD TENSILE STRENGTH = 28 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 18, 2005
09:21 am

Work Order No : 0024899
Project Name : D2735-1
Project For : WK550
Work Order Type : Main
Main WO Number :
House Part Number : D2735-1
Description : Lug Bracket
Manufactured : Yes
Amount Req'd : 50
Amount Done : 0
Start Date : 11-18-05
Est Finish Date : 12-15-05
Act Finish Date :
Drawings Reqd : No
Ok for Approval :
Approval Rec'd : \$0 Posted to Finished Goods

Department Code:
Burden Flags : NNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss)	0.00	0.00



New Zealand Steel Limited
Glenbrook, South Auckland
Postal: Private Bag 92121, Auckland, New Zealand
Telephones: (09) 375 8999 / 375 8111 Auckland
(09) 235 8089 / 235 3535 Waiuku
Fax: (09) 375 8959

TEST CERTIFICATE

Ref. 5078/21768

CUSTOMER		Wilkinson		SPECIFICATION		ASTM A1011 CS Type B												CERTIFICATE No		TC109570								
CUSTOMER O/N		90-31N-544		PRODUCT		HOT-ROLLED PICKLED & OILED												PAGE		1 of 1								
MILL O/N		471702		DIMENSIONS		0.119" x 48" x Coil												DATE		23 April 2005								
PACK NUMBER	(Sample) HEAT No	CHEMICAL COMPOSITION PERCENT														MECHANICAL TESTS (TEST SPECIFICATION - ASTMA370)												
		C	Si	Mn	P	S	Cu	Ni	Cr	Mo	V	Nb	Ti	Al	B	N2	CE(%)	BEND 180°	YIELD	T.S.	%ELONG G.L.=	HARDNESS	r	LENGTH (feet)				
		x100		x1000												x10000	x100											
HP-959386-00	640944	5	1	19	12	20	12	18	19	1	5	1	1			Good							820					
HP-959387-00	640944	5	1	19	12	20	12	18	19	1	5	1	1			Good							837					
HP-959388-00	640944	5	1	19	12	20	12	18	19	1	5	1	1			Good							837					
HP-959389-00	640944	5	1	19	12	20	12	18	19	1	5	1	1			Good							827					

YIELD (A)=0.2% PROOF STRESS (B)=LOWER YIELD STRESS	GAUGE LENGTH (G.L.) (A)=200mm (B)=50mm	PLASTIC STRAIN RATIO (r) (C)=2" (D)=5.65 ! So (F)=8"	IMPACT TEST (A)=0 (B)=90 (C)=45 (D)=(r0+r90+2r45)/4	(C)=5mm x 5mm (D)=2.5mm x 10mm (E)=5mm x 10mm	CARBON EQUIVALENT VALUE (CE) (A)=C+Mn/6 (B)=C+Mn/6+(Cr+V+Mo)/5+(Cu+Ni)/15 (C)=C+Mn/6+Si/24 (D)=
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WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED
WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

APPROVED *Satish Misra*
QC METALLURGIST